

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027758**Date Inspected:** 07-Jun-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** jobsite**CWI Name:** William Sherwood**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

At the start of the shift this Quality Assurance Inspector (QA) traveled to the SAS project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) welding and Quality Control (QC) personnel. The observations and inspections were performed as noted below:

OBG 13W-14W West Drop-In

QAI observed the welding of the back gouged backside of weld joint 13W-14W-W2.2. The welding was being performed by Michael Jimenez in the 4G position using the Shield Metal Arc Welding (SMAW) Process at 129 amps using an E7018H4R consumable electrode with Welding Procedure Specification. Welding parameters were verified to be within the range of Welding Procedure Specification ABF-WPS-D15-F1200A, as recorded by Tony Sherwood QC Inspector, and randomly verified by this QAI.

OBG Suspender Brackets

This QAI observed Magnetic Particle Testing (MPT) performed by QC Technician William Sherwood QC on the stiffeners X-464-12B, and X-464-12A to suspender bracket PPE-104E and PPE-106E welds. Mr. Sherwood performed the testing using Parker Contour Probe Model B300, Serial #19882. Red powder was used to provide contrast. No indications were noted.

This QAI performed Magnetic Particle Testing (MPT) of welds at a frequency of 10% of the total weld length on the stiffeners X-464-12B, and X-464-12A to suspender bracket PPE-104E and PPE-106E welds. The testing was

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performed using Parker Probe Model DA-400, Serial Number 16991, Calibration Date 5/10/12. No indications noted

This QAI observed the completion of welding on stiffeners x464-12B of the east side of Suspender Bracket PPE-104W. The welding was being performed by Eric Sparks in the 3G and 4G position using the Shield Metal Arc Welding (SMAW) Process. The weld was being produced at 125 amps using an E7018H4R consumable electrode. Welding parameters utilized were verified to be within the range of Welding Procedure Specification ABF-WPS-D15-F1200A.



Summary of Conversations:

There were general conversations with Quality Control Inspector William Sherwood, at the start of the shift regarding the location of welding, inspection personnel scheduled for this shift. All observations were relayed to Danny Reyes and Bill Levell.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510 385 5910, who represents the Office of Structural Materials for your project.

Inspected By:	Daggett,Matt
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Quality Assurance Inspector

Reviewed By:	Levell,Bill
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QA Reviewer
